



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00531-3G-PO

Job Sheet 185300



Part No: RBW6405G00531-3G-PO

Job Qty: 2 ea

Part Name: Tail Rotor Damper Length Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6405G00531-3G Rev.A IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		12/17/18	0.00	0.00	Purchasing		DEC 18 2018
110	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging2		DEC 18 2018
120	QC	2 pcs		12/17/18	0.00	0.00	QC6		61
130	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging3		DEC 18 2018
140	QC21-FG	2 Ea		12/17/18	0.00	0.00	QC21		21 DEC 20 2018

Part Op 100 - Issue P/O: 041347 MANUFACTURE RBW6405G00531-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G00531-3GP	Tail Rotor Damper Length Adjustment Tool	2 pcs (1 ea)	100-Purchasing	5139019

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6405G00531-3GP	2	0	0

Part Specifications

Specifications could not be found.



Container No: S139025



Part: RBW6405G00531-3G

Job No: 185300

Serial No/Batch: S139025

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 12/19/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

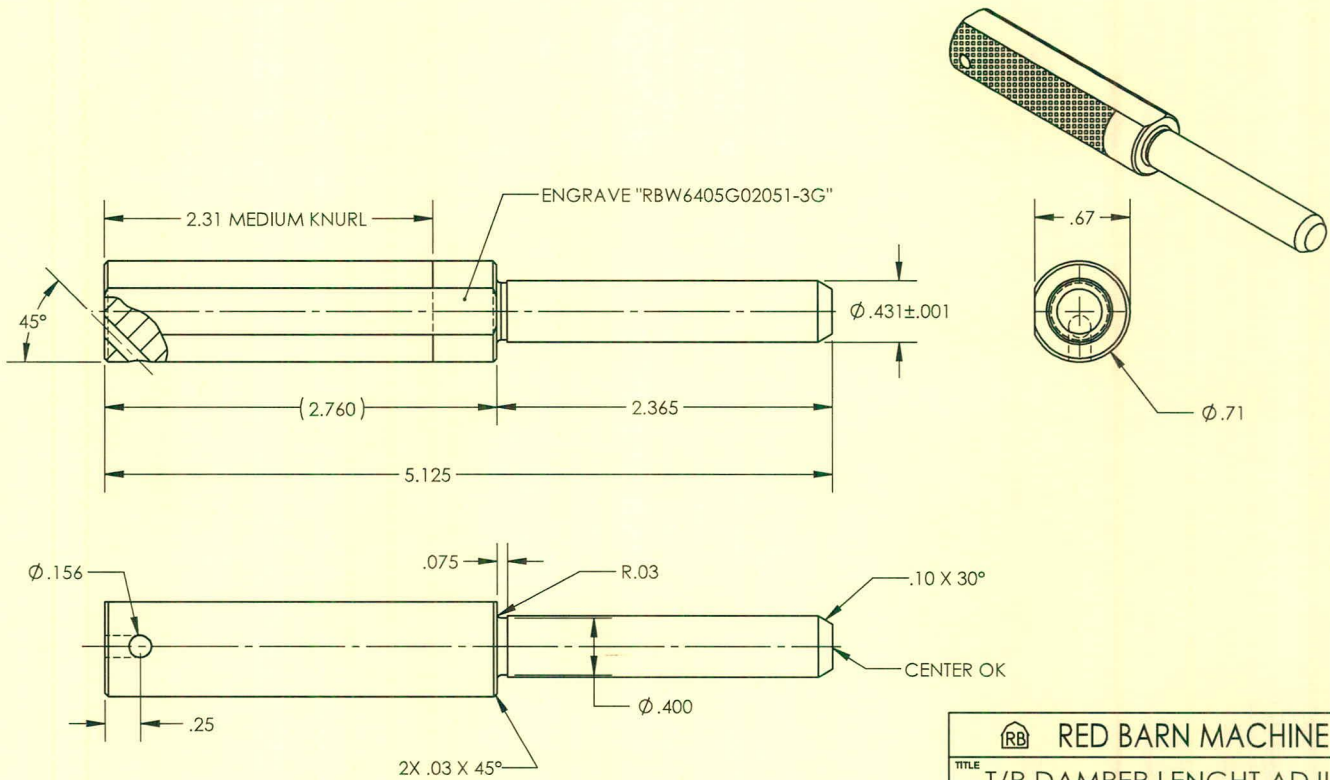
Plex 10/24/18 2:35 PM dart.Lussier.Patrick

DEC 18 2019
DEC 18 2019

100%

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D ENGRAVE NOTE WAS "3G6405G0251" IS "RBW6405G02051-3G"	2/8/2013	BIM	RJC

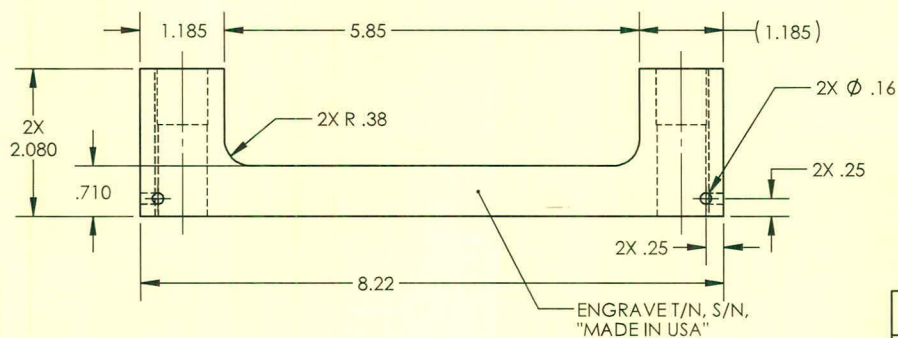
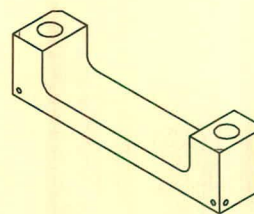
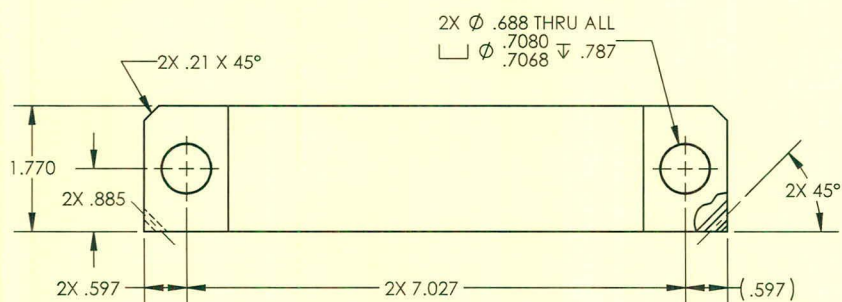


(-3)
PIN

RED BARN MACHINE	
TITLE T/R DAMPER LENGHT ADJUST	
DWG NO. RBW6405G00531-3G-3	REV A
MAT'L 4140 O & T	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	FEAT FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:1	DATE 12/12/2012
SHEET 3 OF 3	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

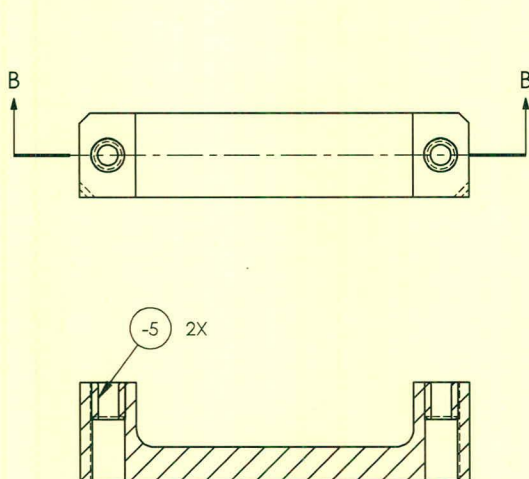


(-1)
BASE

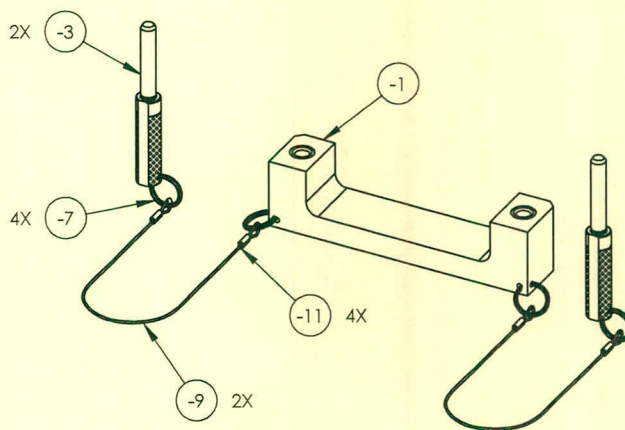
 RED BARN MACHINE	
TITLE T/R DAMPER LENGHT ADJUST	
DWG NO. RBW6405G00531-3G-1	REV A
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	APPROVED  TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL AW139
SCALE 1:2	DATE 12/12/2012
SHEET 2 OF 3	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CHD -7 WAS MCMASTER-CARR #90177A228 IS MCMASTER-CARR #90177A218. CHD ENGRAVE NOTE WAS "3G6405G00531" IS "RBW6405G00531-3G".	2/5/2013	BIM	SE



SECTION B-B
SCALE 1 : 3



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	1-7/8 X 2-1/8 X 8-3/8	2
			-3	2	PIN	4140 Q & T	Ø3/4 X 5-1/4	3
	B/O		-5	2	BUSHING	STEEL	CARR LANE # PM-18-20-11	1
	B/O		-7	4	SPLIT RING	STEEL	Ø1 MCMASTER-CARR #90177A218	1
	B/O		-9	2	LANYARD	COATED STEEL	Ø1/16 X 10 CARR LANE #CL2C	1
	B/O		-11	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1

RED BARN MACHINE	
TITLE T/R DAMPER LENGTH ADJUST	
DWG NO. RBW6405G00531-3G	REV A
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: GILBERT APPROVED: <i>D. Weil</i> TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .016 x 45° OR .018R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 12/12/2012
SHEET 1 OF 3	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367
PO Date: 10/16/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note: SIOP													
2	185392	RBW1205G00231-3Gp			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note: SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note: SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note: SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note: SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note: SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note: SIOP													



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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041367

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note: SIOP 2x DEC 18 2018 ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note: SIOP 2x DEC 18 2018													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note: SIOP 2x DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note: SIOP 2x DEC 18 2018													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note: SIOP 1x DEC 18 2018													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G ORDER 7393 22 Jan 2018													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3x DEC 17 2018 ORDER 7393 22 Jan 2018													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1x DEC 17 2018 ORDER 7393 22 Jan 2018													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1x DEC 17 2018 ORDER 7393 22 Jan 2018													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note: SUB ASSY FOR RBW6405G08632-3G 1x DEC 18 2018 ORDER 7393 06 Jan 2019													



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
												Grand Total: \$23,959.98	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24408
Shipment Date: 18-Dec-2018
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577

Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
2	1	1 ✓	0	0	EA	DART-RBW6205G03832-3GP M/R Blade Blocking/Protecting Assy Order No: 3091 Order Date: 10/12/18 PO Number: PO041327 ✓	5 ✓	3091-02
4	2	2 ✓	0	0	EA	DART-RBW6005G01531-3GP Dial Indicator Main Rotor Damper Support Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-04
5	2	2 ✓	0	0	EA	DART-RBW6405G00531-3GP Tail Rotor Damper Length Adjustment Tool Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	A	3096-05
6	2	2 ✓	0	0	EA	DART-RBW6405G02131-3GP Tail Rotor Blade Damper Attachment Bushing Removal Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	D	3096-06
7	2	2 ✓	0	0	EA	DART-RBW6205G05951-3GP Main Rotor Damper Rod End Wrench Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-07
8	2	2 ✓	0	0	EA	DART-RBW3205G00151-3GP Main Landing Gear Wrench Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-08

Quantity

Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
9	2	2 ✓	0	0	EA	DART-RBW6205G26631-3GP Wrench, Special Nut Removal/Installation Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-09
18	1	1 ✓	0	0	EA	DART-RBW6405G08832-3GP Tail Rotor Bushing Install Tool Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	D	3096-18
19	1	1 ✓	0	0	EA	DART-RBW6405G08732-3GP Tail Rotor Bushing Removal Tool Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	E	3096-19

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1 ✓	DART-RBW6205G03832- 3GP ✓	M/R Blade Blocking/Protecting Assy	5	41327 ✓
2	DART-RBW6005G01531- 3GP	Dial Indicator Main Rotor Damper Support	2	41367
2 ✓	DART-RBW6405G00531- 3GP ✓	Tail Rotor Damper Length Adjustment Tool	DAS 61 9-89 A	41367 ✓
2	DART-RBW6405G02131- 3GP	Tail Rotor Blade Damper Attachment Bushing Removal	D	41367
2	DART-RBW6205G05951- 3GP	Main Rotor Damper Rod End Wrench	2	41367
2	DART-RBW3205G00151- 3GP	Main Landing Gear Wrench	2	41367
2 ✓	DART-RBW6205G26631- 3GP ✓	Wrench, Special Nut Removal/Installation	2 ✓	41367 ✓
1	DART-RBW6405G08832- 3GP	Tail Rotor Bushing Install Tool	D	41367
1	DART-RBW6405G08732- 3GP	Tail Rotor Bushing Removal Tool	E	41367

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

George Theoret

Vankleek Hill, December 19, 2018

